

split

31

Date: Tuesday, 7/17/2007 1:59:08 PM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI-ACCESS STEP RH (FOLDING)
Job Number :	33577		
Estimate Number :	12568		
P.O. Number :	N/A	Part Number :	D412630034
This Issue :	7/17/2007	Drawing Number :	IIN UNDER REVIEW
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	K
Previous Run :	32716	Material :	N/A
Written By :		Due Date :	8/3/2007
Checked & Approved By :		Qty:	Um: Each
Comment :	Est. Rev. A New Issue 06-11-08 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-034 CHG002		
2.0	D2012107	Clevis
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Clevis Pick: Qty Part Number Description Batch 1 D2012-107 Clevis B32051 4X B33585		
3.0	D2803042	Bracket Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2803-042 Bracket Assembly RH B27283 1X B28392 5X		
4.0	D2804042	Bracket Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2804-042 Bracket Assembly RH B26252 1X B29409 2X B25920 1X B27284 2X		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

B33774

[Signature]

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

B33592 1X

B32776 11X *[Signature]*

7.0

D3562042

STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch

33580

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

B28405 6X

B32783 18X *[Signature]*

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

M101189

[Signature]

Date: Tuesday, 11/11/2007 1:59:09 PM

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Process Sheet

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Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M102736

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M104679

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 36.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M105764

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M104986 FX

M105728 16X

Date: Tuesday, 11/11/2008 1:39:09 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M104811 9x
M102067 15x

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M105728

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

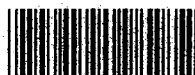
Batch

M101013 90

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104922

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH:

M17045

SB 07/10/12

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JAN-12 @

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-1

Description

Bushing

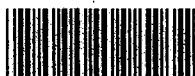
Batch

B32772

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-3

Description

Bushing

Batch

B29847

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

1 D2810-5

Description

Strut

Batch

B32775

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

2 D3396-1

Description

Spacer

Batch

B29496

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M105426

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M101189

[Signature]

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M103915

[Signature]

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M101711

[Signature]

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M101291
M103970

[Signature]

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M104715
M101291

[Signature]

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Job Number: 33577

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 42.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M105792

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M105730

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M105430

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

36.0

QC21

FINAL INSPECTION/W/O RELEASE

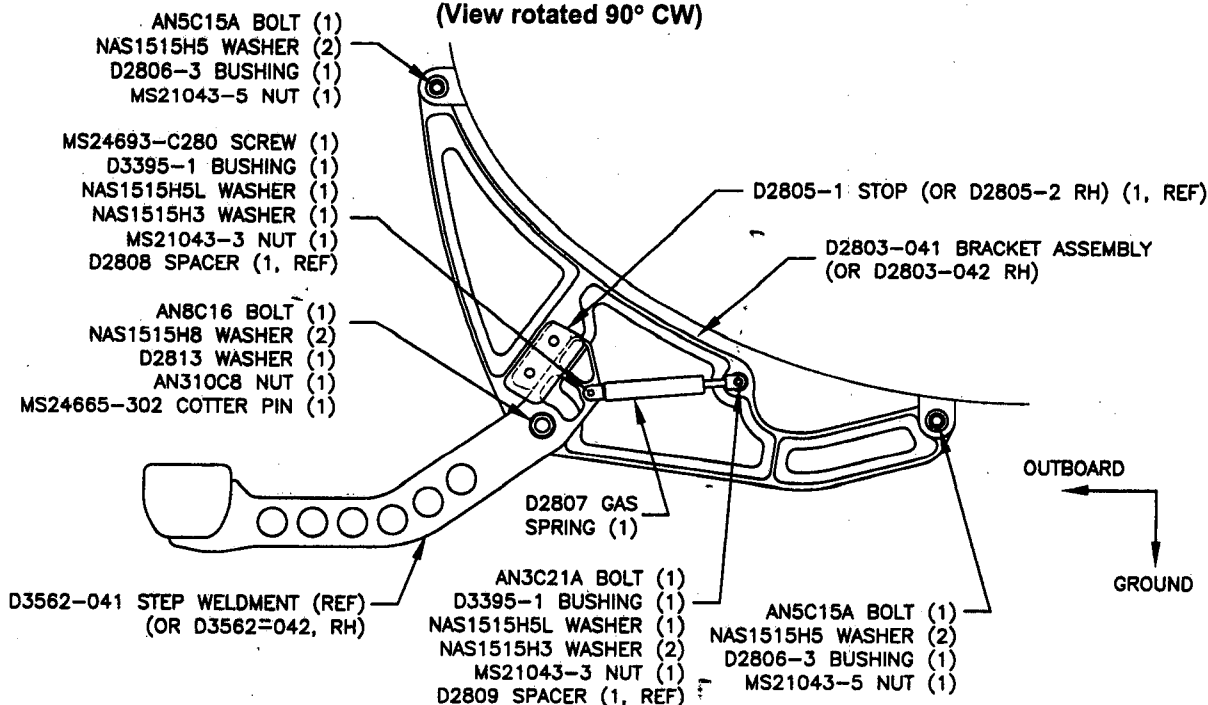


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C20711112

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**
(View rotated 90° CW)